Qty:

Date:

Monday, 05/02/2007 2:28:27 PM

User:

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 30630

Estimate Number P.O. Number

: 10199 : 410

This Issue

: 05/02/2007

S.O. No. : 1)

Prsht Rev. First Issue

: SMALL /MED FAB

: 30630 Previous Run

Written By

Checked & Approved By Comment

: Est A 00.07.17 New Issue EC

-Est Rev:B Now on Waterjet 07-02-05 JLM

Part Number

Material

Due Date

Drawing Name

: D2179 : D2179 REV. B

: HINGE BRACKET PLATE

Drawing Number Project Number Drawing Revision

: N/A

: NIA

: 22/02/2007

60 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.:

0.0096 sf(s)/Unit Total: $0.5733 \, sf(s)$

Material: 5052-H32 (or 6061-T6) 0.040" thick

(M5052H32S.040)

Batch: 11/01 875

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2179

Dwg Rev: 13 Prog Rev: 13

07 02 28



2-Deburr if necessary



3.0

QC2

070228

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0



SECOND CHECK

Comment: SECOND CHECK

HAND FINISHING1

HAND FINISHING RESOURCE #1





5.0



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



Date:

Monday, 05/02/2007 2:28:27 PM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET PLATE

Job Number: 30630

Part Number: D2179

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

POWDER COATING

POWDER COATING

M103141



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0



Comment: INSPECT POWDER COAT

PACKAGING 1





8.0



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9.0 QC21





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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Qty:

Date

Monday, 2/5/2007 8:14:56 AM

Kim Johnston

Process Sheet

Customer

Job Number

: CU-DAR001 Dart Helicopters Services

Estimate Number : 10199

P.O. Number

: 2/5/2007 This Issue : NC

Prsht Rev.

: 11 First Issue : 26077 Previous Run

Written By

Checked & Approved By Comment

: Est A

09.07.17 New Issue EC

S.O. No. :

Type

: MACHINED PARTS

Drawing Name

: HINGE BRACKET PLATE

Part Number

: D2179

: 2/9/2007

D2179 REV. B

Drawing Number

: N/A Project Number ; B

Drawing Revision

Material

Due Date

60 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 5052-H32 .040 Sheet



Total:

Material: 5052-H32 (or 6061-T6) 0.040" thick

0.0096 sf(s)/Unit

(M5052H32S.040)

Batch:

0.5733 sf(s)

SHEAR

2.0

SHEAR



Comment: SHEAR

Comment: Qty.:

Cut blank: 1.645" x 0.800"

3.0 HAAS1 HAAS CNC VERT



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA080 and Dwg D2179

Identify as D2179

4.0

QC2

PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

SECOND CHECK





Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1







Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			:			! \$	
						1	
		· · · · · · · · · · · · · · · · · · ·					
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	
			QA:	N/C Close	d:	Date:	

NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		\/- =:E:4:		A
DATE	STEP	Section A	Initial Chief Eng	Initial Action Description Sign &		Verification Section C	Approval Chief Eng	Approval QC Inspector
			,					
			į.					

NOTE: Date & initial all entries

Qate: '

Monday, 2/5/2007 8:14:57 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET PLATE

Job Number: 30630

Part Number: D2179

Job Number:



Seq. #:

Machine Or Operation:

Description:

HAND FINISHING1

HAND FINISHING RESOURCE #1





Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

11.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	07/63/0
			QA: N/C	Closed:	Date:	

		WORK ORDI	ER NON-CONFORMAN	CE (NCR)		į	
	Description of NC	Corrective Action Section B Varification			Verification	Approval	A
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto
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			•			1	
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Portion Description Section B Section C Chief English

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30630
Description: Hinge Bracket Plate	Part Number:	D2179
Inspection Dwg: D2179 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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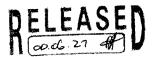
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.350	+/-0.010	0.353	\checkmark		VEIN	
1.170	+/-0.010	1.172	/		vern	
1.520	+/-0.010	1.527	J		VRIN	
0.340	+/-0.010	0.340	1		vern	
0.680	+/-0.010	0.685	1		verN	
Ø0.171	+0.005/-0.000	0.112	/		VETN RADIUS GUI	
R0.13	+/-0.030	RO.13	/		RADIUS GUI	ze

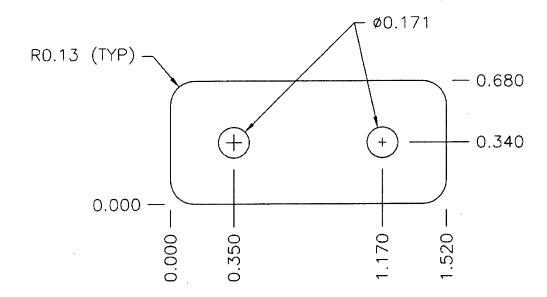
Measured by:	M-M	Audited by:		Prototype Approval:	N/A
Date:	0702 28	Date: 07/03	101	Date:	N/A

Rev	Date	Change	Revised by	Approv <i>e</i> d
Α	04.10.05	New Issue	KJ/JLM A	
			, ()	7.7



	DESIG	DART AEROSPACE KH RF HAWKESBURY, ONTARIO, CANADA				
	CHECK	(ED,	APPROYED	DRAWING NO.	•	REV. B
		4	4	D2179	SHEET	1 OF 1
	DATE			TITLE		SCALE
ļ	00.0	6.20		HINGE BRACKET PLATE		2:1
	Α		95.03.17	NEW ISSUE		
	В		00.06.20	DWG No. D2179 WAS D2399		





MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11)

OR 2024-T3 (QQ-A-250/4) 0.040 THICK

ENGINEERING UNCONTROLLED COPY

FINISH: CHEMICAL CONVENSION COAT PER DART QSI 005 4.1

POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 NOT TO AMENDMENT

SHOP COPY RETURN TO

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WITHOUT NOTICE

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